

Work Order ID 54335

December 8, 2009 8:46:50 AM



Page 1

Item ID: D3762-041

Accept



Setup Start



Revision ID:

Item Name: Front Leg Fitting Assembly

Stop



Start Date: 08/12/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: RF

Date: 08/12/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3762	Rev A

100	Pick Kit	0.00
-----	----------	------



Packaging

Memo

0.00

Packaging

09/12/09
10

110	Large Fab	0.00
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Large Fab

Memo

0.00

Large Fab

1-assemble as per dwg D3762 using locating pins DT9014 and tack weld parts in place
2- take pins out before welding 3-weld as per dwg D3762 per

QSI004 Alum. rod Batch: 111385

Make chamfer before welding

sp 09 12 17.

120	QC9- Inspect visual per QSI004- Fusion Welds	0.00
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QC

Memo

0.00

Quality Control

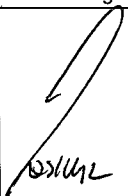

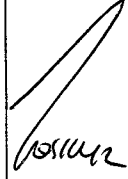

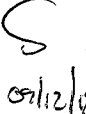
DD 09.12.17

Pro →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3762-041 PAR #: N/A Fault Category: Lge Fns NCR: Yes No DQA: 11 Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 54335		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/12/18	120	Found at 120 inspection qty 45 Parts with crack in the weld on in D3762-3. R.L. <u>Process</u> within welding a thick walled part to a thin walled part		- SCRAP + Destroy no repl/mt. Qty 45	SP 10.01.11	 09/12/18		 09/12/18
								 09/12/18

NOTE: Date & initial all entries

Work Order ID 54335

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Page 2

Item ID: D3762-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Leg Fitting Assembly

Start Date: 08/12/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 02/12/18			(29)	85		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	B 09-12-21			(29)			
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	JL 09-12-21			(129)	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54335

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Item ID: D3762-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Leg Fitting Assembly

Start Date: 08/12/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location JS1

0.00



Packaging

Memo

0.00

Packaging

9/12/21 (22) SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/21 JG

C Log 11/2/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 8:47:03 AM

Page 1

Work Order ID: 54335

Parent Item: D3762-041

Parent Item Name: Front Leg Fitting Assembly


Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3762-3  Tube		Manufactured	No			100	Each	34.0000	40.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

34

41008

19

44339

15

D3762-1

Manufactured

No

110

Each

14.0000

80.0000

Fitting

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

42731

14

543666-

24
30

09-12-15

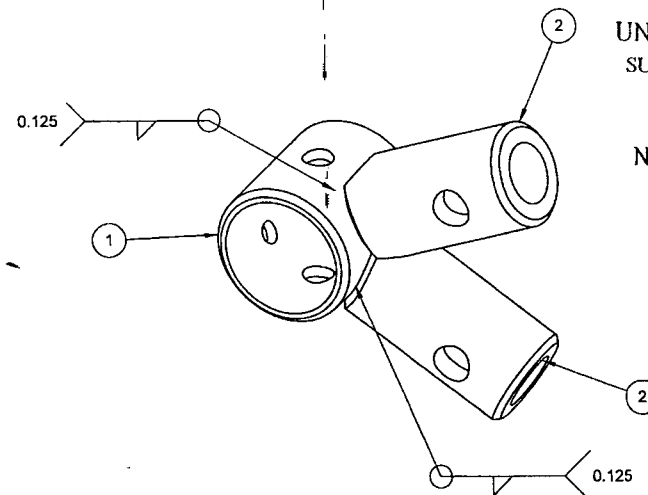
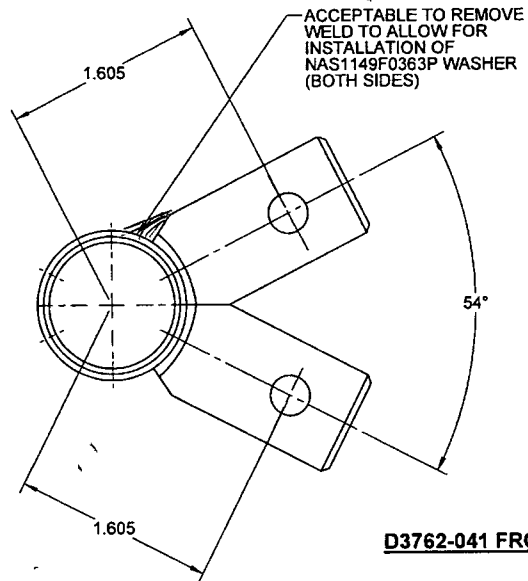
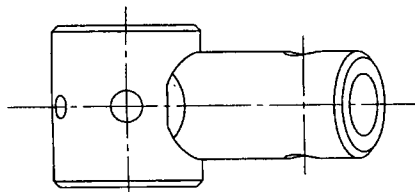
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

SHOP COPY
RETURNED
ENGINEER
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT WORK
NO. 54/335
11/09/12-8

RELEASED
08-02-16/11/12

D3762-041 FRONT LEG FITTING ASSY

NOTES:

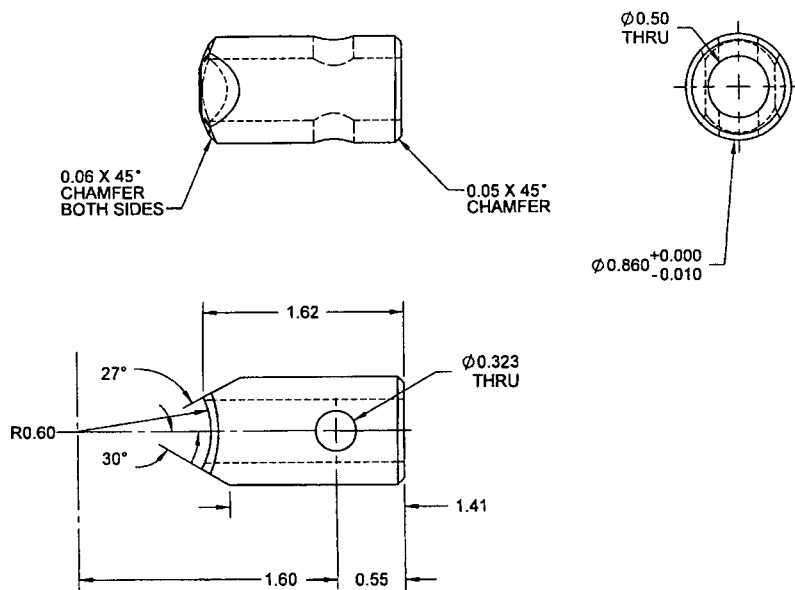
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3762
REV. A
SHEET 1 OF 3
SCALE NTS

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D3762-1 FITTING

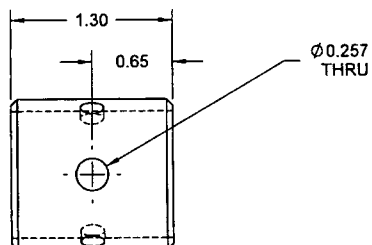
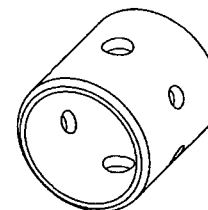
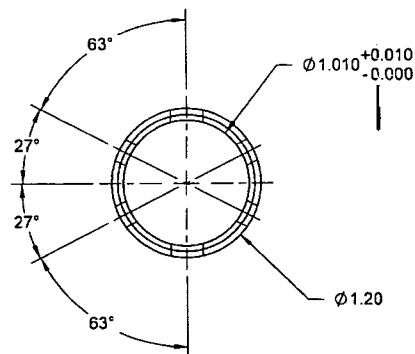
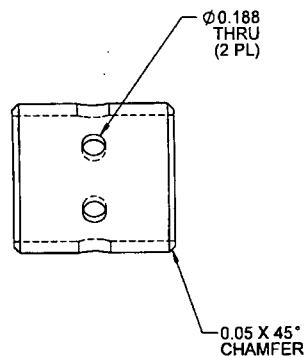
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

RELEASED
08-06-16

w/o 54335

DESIGN	HS	DART AEROSPACE LTD	
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CHECKED	<i>Ret</i>	DRAWING NO.	REV. A
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FRONT LEG FITTING	NTS
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D3762-3 TUBE

RELEASED
08-06-16/10

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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